

**Work Order ID 64068**

Page 1

Wednesday, November 24, 2010 8:33:07 AM

Item ID: D3763-3

Revision ID:

Item Name: Tube

Start Date: 11/24/2010 Start Qty: 8.00

Required Date: 11/30/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan:

Date: 10/11/24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3763	Rev B

100



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA751 Rev: B & Dwg D3763 Rev: B  2-Deburr  
per dwg D3763

SA 10/12/16

S D

110



QC2- Inspect parts off machine FAI/FAIB

Quality Control

Memo

0.00

SA 10/12/16

S D

120



QC8- Inspect parts - second check

Quality Control

Memo

0.00

QC

B.A 10/12/17

S D

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 64068**

Page 2

Wednesday, November 24, 2010 8:33:07 AM

Item ID: D3763-3

Revision ID:

Item Name: Tube

Start Date: 11/24/2010 Start Qty: 8.00

Accept



Setup Start



Required Date: 11/30/2010 Req'd Qty: 8.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: *W*Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

*U*

10-12-17

*B*

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/12/2010**U 10-12-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

Wednesday, November 24, 2010 8:33:11 AM

Work Order ID: 64068



Parent Item: D3763-3



Parent Item Name: Tube

Start Date: 11/24/2010

Required Date: 11/30/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-05-23 new issue DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Msg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.250		Purchased		No		100	f	51.4821	0.109	0.917895		SD 10/12/16	

6061-T6 Round Bar 1.250



Location	Loc Qty	Loc Code
MAT013	51.48205	
113457	31.48205	
113550	20	

1 foot no loes

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	64068
Description: Tube	Part Number:	D3763-3
Inspection Dwg: D3763	Rev: B	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>S</u>	Audited by: <u>H.A</u>	Prototype Approval:	N/A
Date: <u>10/12/16</u>	Date: <u>10/12/17</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	

8  
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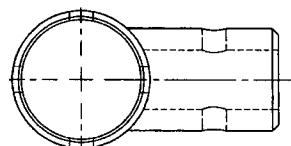
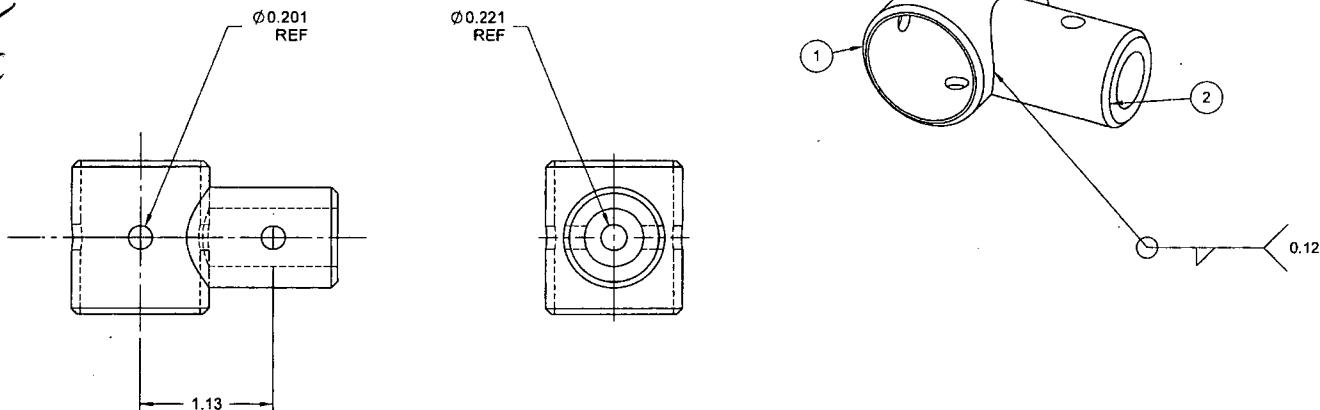
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 04068

*BS 10-11-24*



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3763-3	TUBE	1
2	D3763-1	FITTING	1

D3763-041 END FITTING ASSY

RELEASED  
*08.07.10/M*

B	CHANGE HOLES SIZE, ADD -7 PART AND -045 ASSY		HS	08.06.23
A	NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	DART AEROSPACE LTD		
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>MM</i>	DRAWING NO.	REV. B	
MFG. APPR.	<i>MM</i>	D3763	SHEET 1 OF 9	
APPROVED	<i>MM</i>	TITLE	SCALE	
DE APPR.	<i>MM</i>	END FITTING	NTS	
DATE	08.06.23			

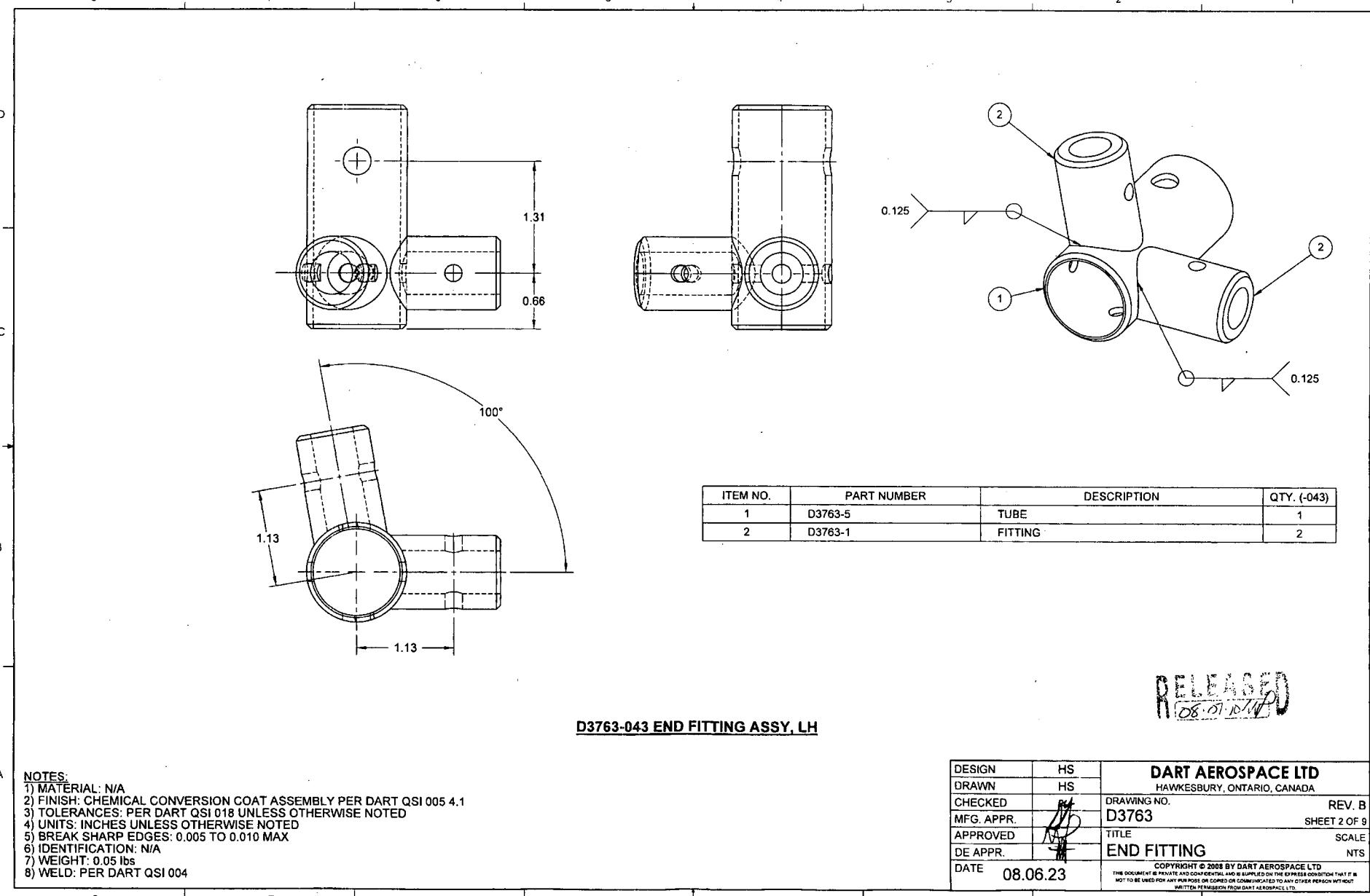
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A  
NOTES:  
1) MATERIAL: N/A  
2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 0.03 lbs  
8) WELD: PER DART QSI 004

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

w/6 04068



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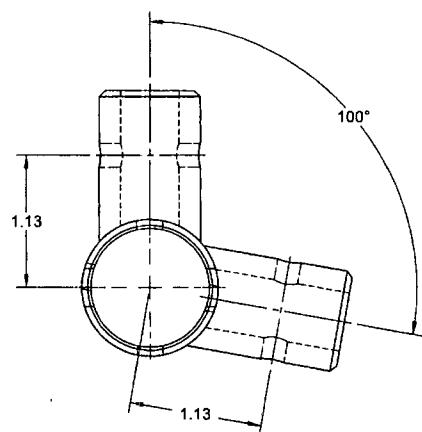
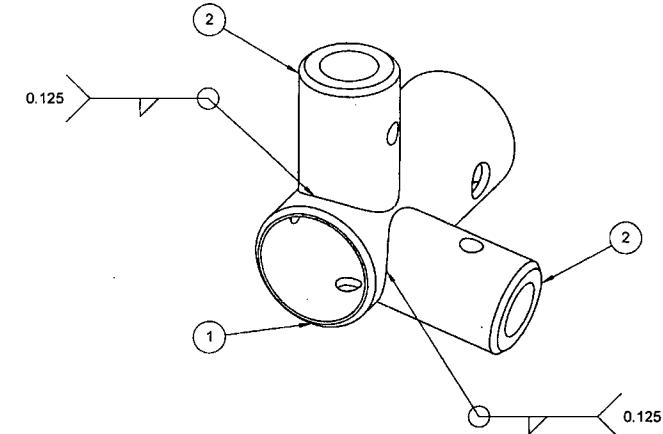
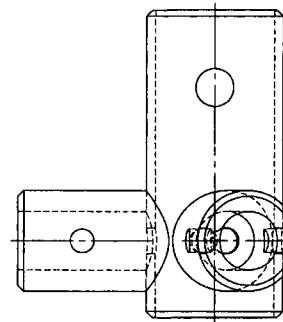
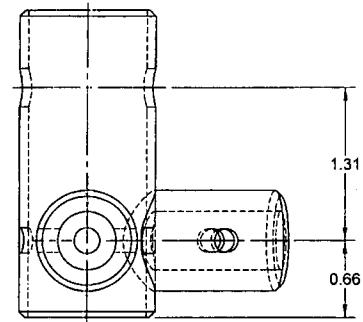
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ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-6	TUBE	1
2	D3763-1	FITTING	2

**D3763-044 END FITTING ASSY, RH**

RELEASED  
08-07-10 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT ASSEMBLY PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.05 lbs
- 8) WELD: PER DART QSI 004

8

7

6

5

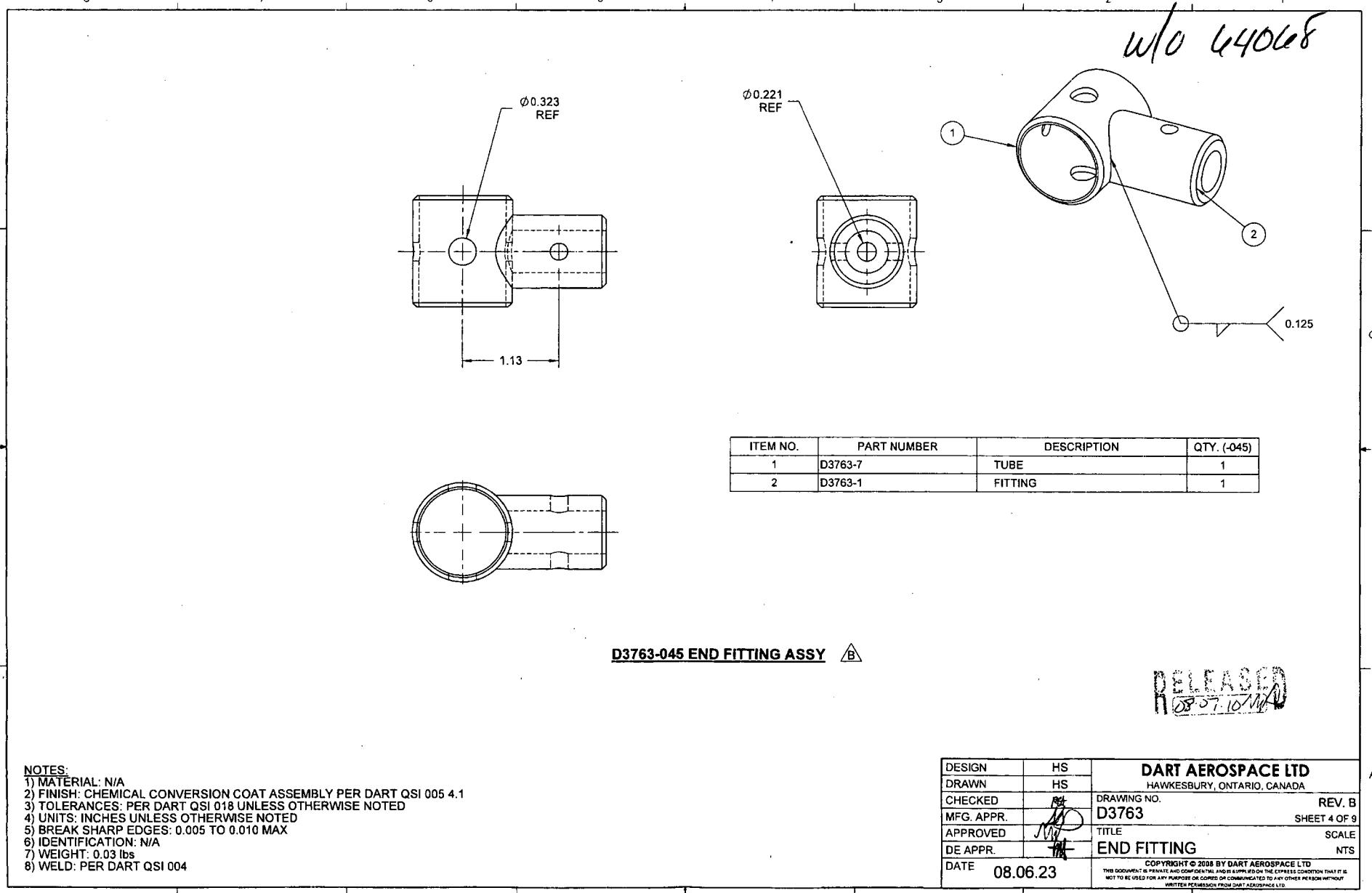
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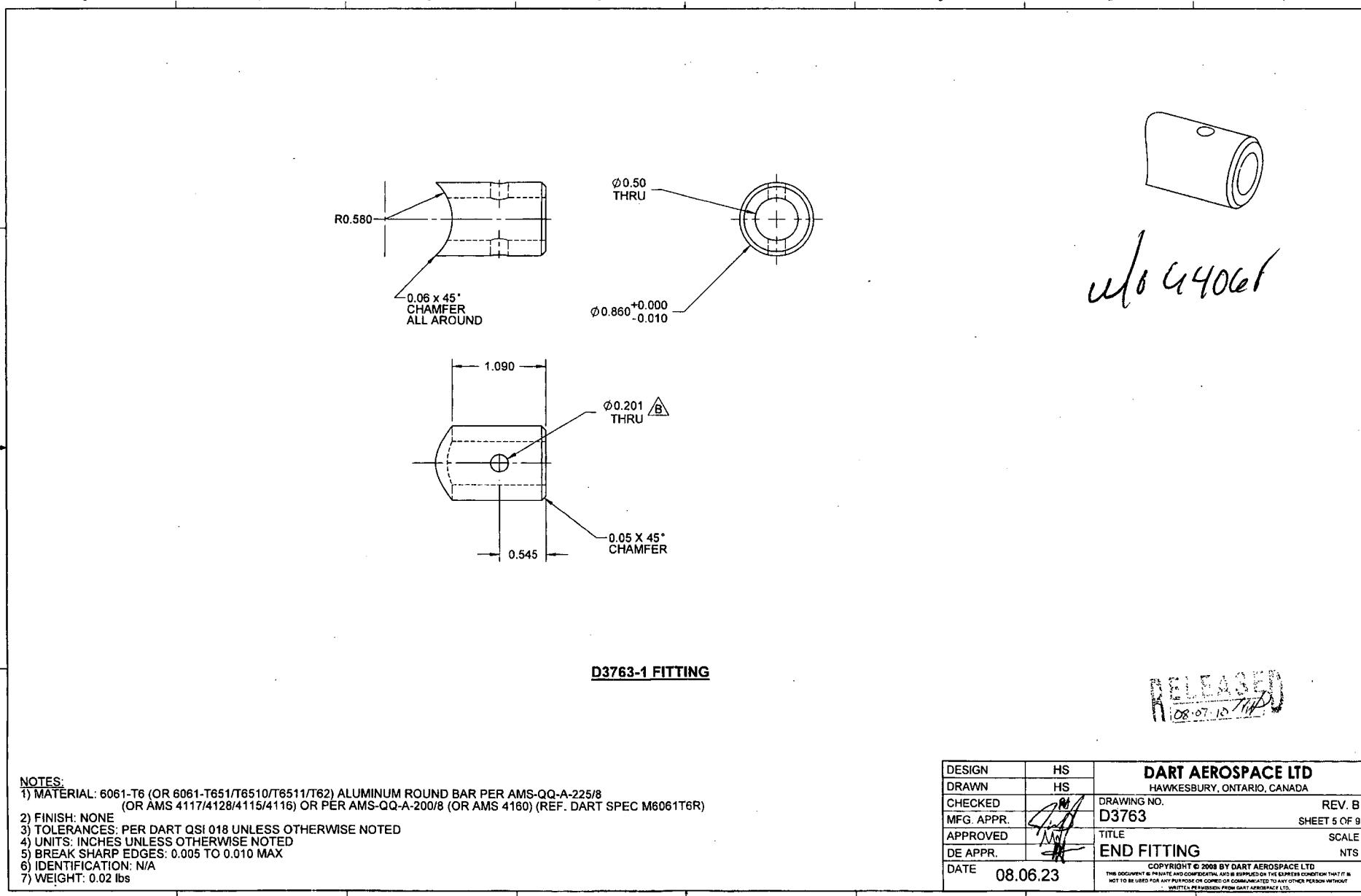
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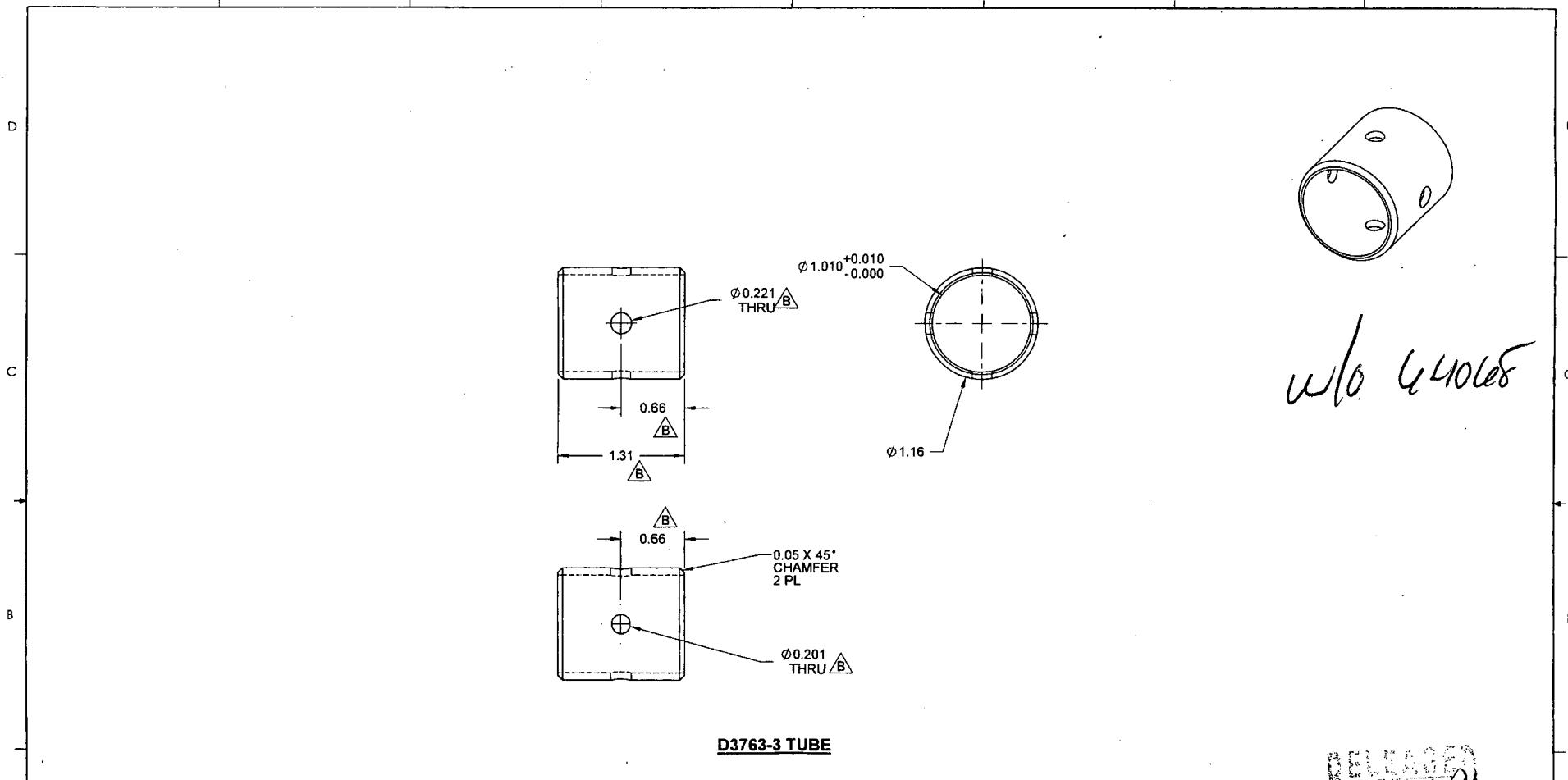
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DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO. REV. B	
MFG. APPR.	AP	D3763 SHEET 3 OF 9	
APPROVED	AP	TITLE SCALE	
DE APPR.	AP	END FITTING NTS	
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8 7 6 5 4 3 2 1



D3763-3 TUBE

08.06.23

## NOTES:

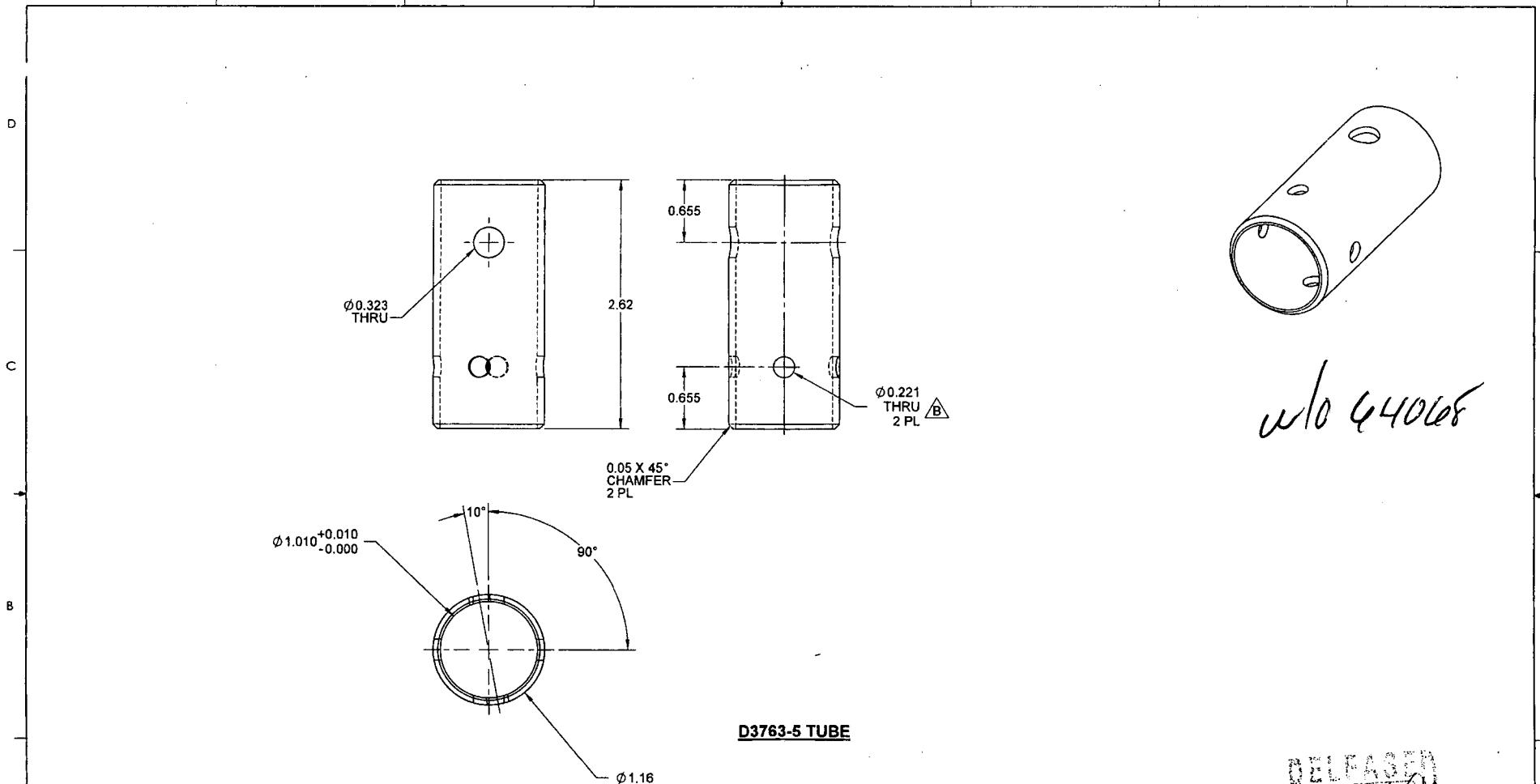
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
		D3763	SHEET 6 OF 9
MFG. APPR.			SCALE
APPROVED			NTS
DE APPR.			
DATE	08.06.23		

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8 7 6 5 4 3 2 1



w/o 64068

RELEASED  
68-0710

A NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PL	DRAWING NO.	
MFG. APPR.	PL	D3763	REV. B
APPROVED	PL	TITLE	SCALE
DE APPR.	PL	END FITTING	NTS
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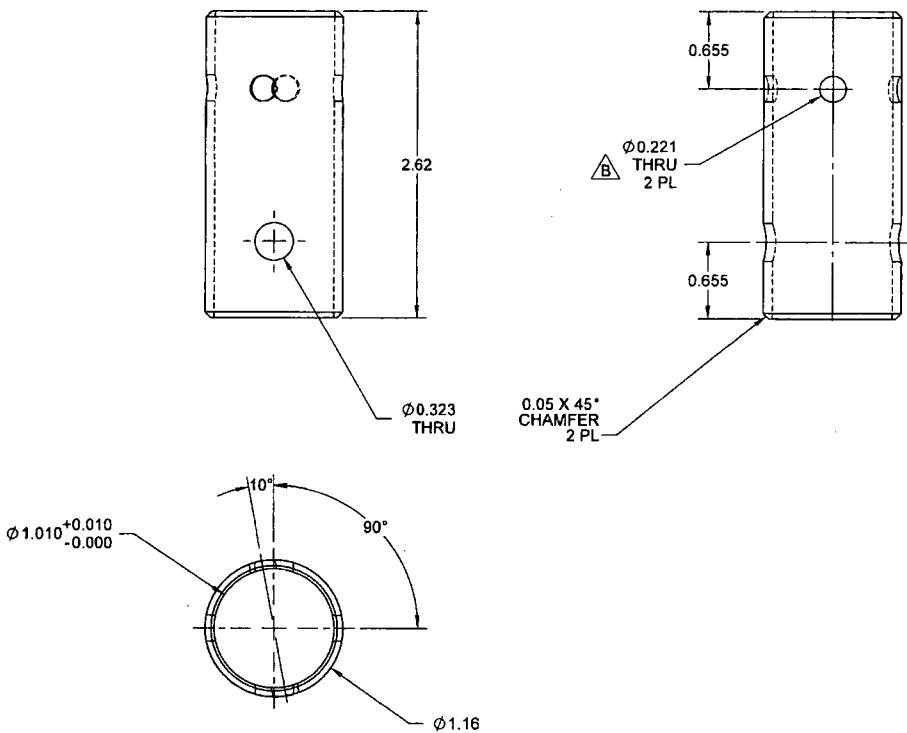
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## NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs



D3763-6 TUBE

RELEASED  
08-07-10

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BD</i>	DRAWING NO.	
MFG. APPR.		D3763	REV. B
APPROVED	<i>MM</i>		SHEET 8 OF 9
DE APPR.	<i>MM</i>	TITLE	SCALE
		END FITTING	NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

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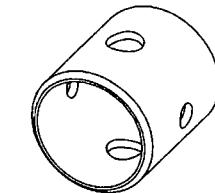
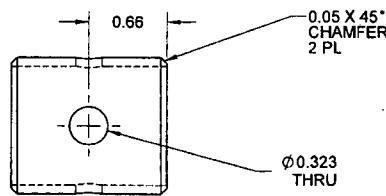
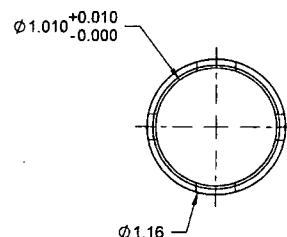
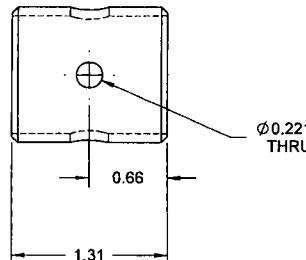
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u/o 6406d

**D3763-7 TUBE** 

RELEASED  
08-07-10

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF. DART SPEC M6061T6R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

8 7 6 5 4 3 2 1

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
		D3763	SHEET 9 OF 9
MFG. APPR.		APPROVED	SCALE
APPROVED		TITLE	NTS
DE APPR.		END FITTING	
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